

Work Order ID 52349

Tuesday, September 22, 2009 12:26:27 PM



Page 1

Item ID: D3001-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Rmt

Date:

09-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3001	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
	1-Cut as per Dwg D3001								
	Dwg Rev: <i>B</i>								
	Prog Rev: <i>B</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
	Quality Control								

B 9-11-6

(13)

LB 9-11-6

Work Order ID 52349

Tuesday, September 22, 2009 12:26:27 PM



Page 2

Item ID: D3001-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

→ Sorlulob



QC

Memo

0.00

(13)

/

Quality Control

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Scuff surfaces with 80grit sandpaper per QSI 006
2-Deburr.

09/11/09 (13)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

09/11/09 (13)

Quality Control

Work Order ID 52349

Tuesday, September 22, 2009 12:26:27 PM



Page 3

Item ID: D3001-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

el 09/11/10

(13x) ~~0~~

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

mo 09/11/10

X13



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 178

0.00



Packaging

Memo

0.00

Packaging

9/11/10 (13x) SP

Work Order ID 52349

Tuesday, September 22, 2009 12:26:27 PM



Page 4

Item ID: D3001-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/11 HJ

MF
09-11-10

Picklist Print

Tuesday, September 22, 2009 12:26:26 PM

Page 1

Work Order ID: 52349



Parent Item: D3001-1RevB



Parent Item Name: Doubler

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	60.7600	4.4735	10.5		



5052-H32 .040 Sheet



IB 9-11-6

M6061T6S.040 c20911106

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

60.76

101875

10

102723

1

104921

6.5

106900

2

107513

4.5

109058

36.76

113004

113004

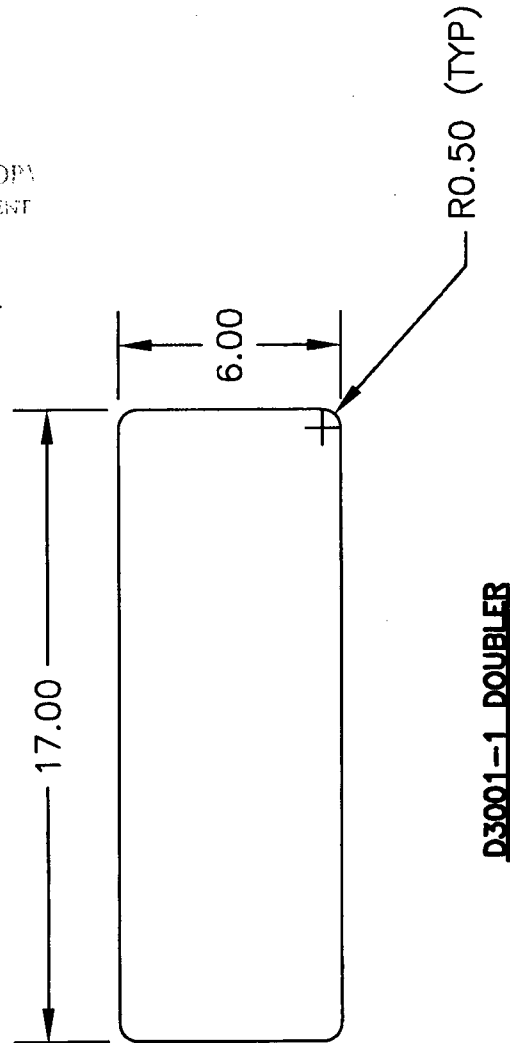
DART

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3001	REV. B SHEET 1 OF 1
DATE 06.10.06		TITLE DOUBLER	SCALE 1:5
A	01.03.21	NEW ISSUE	
B	06.10.06	ADD BONDING PREP NOTE	

RELEASE

06.11.13

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52349

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32/H34 SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.040) OR ALUMINUM 6061-T6 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) PREPARE FOR BONDING TO COMPOSITE STRUCTURE PER DART QSI 006 4.10
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS TO 0.010 MAX

**Copyright © 2001 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.